

Work Order ID 149508***149508***

Page 1

Monday, July 25, 2016 2:26:05 PM

Item ID: D350-607-143 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: AS350/AS355 Automatic Lid Opener (Long & Short Basket, split lid)
Start Date: 7/15/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/25/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: DAS Date: JUL 27 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-1	A	AUG 05 2016	DAS 5 9-89						SH 1608-11
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-607-143 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

AUG 15 2016

① PK

DAS
28
9-89

AUG 10 2016

DAS
27
9-89

AUG 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
Root Cause ☐ Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter			FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence		
☐ OTHER : _____					

Work Order ID 149508

Monday, July 25, 2016 2:26:05 PM

149508

Page 2

Item ID: D350-607-143

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: AS350/AS355 Automatic Lid Opener (Long & Short Basket, split lid)

Start Date: 7/15/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/25/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130						DAS			
Packaging	Memo	0.00				27			
Packaging	Identify and pack for shipping as per PPP D350-607-143					9-89			
	Location: _____								
	PPP rev: _____								
	<i>fg 023</i>								
140	QC21- Final Inspection - Work Order Release	0.00							
140						DAS			
QC	Memo	0.02				21			
Quality Control						9-89			

AUG 15 2016

AUG 16 2016

AUG 16 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER :																																																																									

Picklist Print

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Page 1

Work Order ID: 149508

149508

Parent Item: D350-607-143

D350-607-143

Parent Item Name: AS350/AS355 Automatic Lid Opener (Long & Short Basket, split lid)

Start Date: 7/15/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revC DD 10.01.18 verified by:EC
545 DD 10.04.19 verified by:EC

IPP RevB: as
IPP RevC: as per ecn10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3953-7 *D3953-7* Spring Spacer		Manufactured	No			110	Each	55.0000	1	1			PC DAS 28 9-89
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	----------------

Location Loc Qty Loc Code

ST062	43	
144665	27	
147641	16	
ST064A	12	
148382	12	

DAS
27
9-89

D3953-3 *D3953-3* Gas Spring Stud, Lid		Manufactured	No			110	Each	36.0000	1	1			PC DAS 28 9-89
---	--	--------------	----	--	--	-----	------	---------	---	---	--	--	----------------

Location Loc Qty Loc Code

ST062	36	
144775	23	
147675	13	

DAS
27
9-89

D3953-5 *D3953-5* Gas Spring Stud, Base		Manufactured	No			110	Each	8.0000	1	1			PC DAS 28 9-89
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	----------------

Location Loc Qty Loc Code

ST062	8	
124030	8	

DAS
27
9-89

AUG 10 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By 					
				Lead hand / Supervisor Approval Verification 					
				QC / QA Coordinator Approval 					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
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Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Picklist Print

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Work Order ID: 149508

149508

Parent Item: D350-607-143

D350-607-143

Parent Item Name: AS350/AS355 Automatic Lid Opener (Long & Short Basket, split lid)

Start Date: 7/15/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

D3953-9	Manufactured	No	110	Each	89.0000	2	2	P<	DAS 28 9-89
D3953-9						**			
Gas Spring Washer									

DAS
27
9-89

Location	Loc Qty	Loc Code
ST062	89	
145912	61	
147022	28	

D3953-11	Manufactured	No	110	Each	25.0000	1	1	P	DAS 28 9-89
D3953-11						**			
Gas Spring Spacer									

DAS
27
9-89

Location	Loc Qty	Loc Code
ST062	25	
105464	25	

D3953-15	Manufactured	No	110	Each	17.0000	1	1	P<	DAS 28 9-89
D3953-15						**			
Gas Spring Bracket									

DAS
27
9-89

Location	Loc Qty	Loc Code
ST062	17	
99186	17	

D3953-17	Manufactured	No	110	Each	33.0000	1	1	P<	DAS 28 9-89
D3953-17						**			
Gas Spring Spacer									

DAS
27
9-89

Location	Loc Qty	Loc Code
ST062	33	
141477	5	
145690	28	

AUG 10 2016

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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
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Work Order ID: 149508

149508

Parent Item: D350-607-143

D350-607-143

Parent Item Name: AS350/AS355 Automatic Lid Opener (Long & Short Basket, split lid)

Start Date: 7/15/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

D3969-1 Manufactured No

110 Each

11.0000

1

D3969-1

Spring (Basket Lid)

DAS
27
9-89

Location

Loc Qty

Loc Code

ST365

11

131003

1

141700

10

AN3C11A

Purchased No

110 Each

41.0000

2

AN3C11A

BOLT

DAS
27
9-89

Location

Loc Qty

Loc Code

OVER002

28

M132035

28

ST349

13

M131957

13

AN3C15A

Purchased No

110 Each

27.0000

2

AN3C15A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

ST348

27

M125374

27

AN310-4

Purchased No

110 Each

95.0000

2

AN310-4

Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

25

M127815

25

OVER007

50

M134955

50

ST331

20

M134762

20

AUG 10 2016

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																										
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 149508

149508

Parent Item: D350-607-143

D350-607-143

Parent Item Name: AS350/AS355 Automatic Lid Opener (Long & Short Basket, split lid)

Start Date: 7/15/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

110

Each

920.0000

4

4

MS21043-3

Nut

**

PC DAS 28 9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

11

m130673

11

GA

237

m133990

237

OVER007

400

m135058

400

ST302

86

m134861

86

ST304

106

m131340

106

DAS 27 9-89

4

MS24665-2-12

Purchased

No

110

Each

168.0000

2

2

MS24665-2-12

COTTER PIN

**

PC DAS 28 9-89

Location

Loc Qty

Loc Code

ST289

168

125044

168

2

DAS 27 9-89

AUG 10 2016

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
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Picklist Print

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Work Order ID: 149508

149508

Parent Item: D350-607-143

D350-607-143

Parent Item Name: AS350/AS355 Automatic Lid Opener (Long & Short Basket, split lid)

Start Date: 7/15/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

110

Each

4,766.000

14

4

NAS1149C0332R

WASHER

**

PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

1334

m135046

1334

GA

141

m133284

141

ST266

3291

m134736

1291

m135274

2000

4

NAS1149C0432R

Purchased

No

110

Each

1,977.000

2

2

NAS1149C0432R

WASHER

**

PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

801

m125807

427

m134676

374

ST266

1176

m134676

176

m135297

1000

2

AUG 10 2016

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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6.3 D350-607-141/-143/-145 AUTOMATIC LID OPENER INSTL

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-607-141	AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET)
	X		D350-607-143	AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)
		X	D350-607-145	AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET)
2		1	D3953-1	GAS SPRING BRACKET
2	1	1	D3953-3	GAS SPRING STUD (LID)
2	1	1	D3953-5	GAS SPRING STUD (BASE)
2	1	1	D3953-7	GAS SPRING SPACER
4	2	2	D3953-9	GAS SPRING WASHER
2	1	1	D3953-11	GAS SPRING SPACER
2		1	D3953-13	GAS SPRING SPACER
	1		D3953-15	GAS SPRING BRACKET
	1		D3953-17	GAS SPRING SPACER
2	1	1	D3969-1	GAS SPRING
4	2	2	AN3C11A	BOLT
	2		AN3C15A	BOLT
4		2	AN3C16A	BOLT
4	2	2	AN310-4	CASTELLATED NUT
8	4	4	MS21043-3	NUT
4	2	2	MS24665-212	COTTER PIN
8	4	4	NAS1149C0332R	WASHER (OR AN960C10L)
4	2	2	NAS1149C0432R	WASHER (OR AN960C416L)